

Date: Wednesday, 12/7/2005 3:43:20 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER		
Job Number	: 25156					
Estimate Number	: 10227					
P.O. Number	: N/A			Part Number	: D2151	
This Issue	12/7/2005	S.O. No.	N/A	Drawing Number	: D2151 REV. A	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	12/7/2005	Type	MACHINED PARTS	Drawing Revision	: A	
Previous Run	: 24493			Material	: N/A	
Written By	<u>See COMMENT Below</u>			Due Date	12/15/2005	Qty: 25 Um: Each
Checked & Approved By	<u>See ABOVE. USER & DATE</u>					
Comment	: Est C 00.10.23 Re-format (mpp 2101) EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.0368 sf(s)/Unit Total : 0.9188 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch: M19059

M19295

FT 05.12.07

25

25

25

12

13

14

15

16

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blank: 2.194" x 2.300" +/-0.005"

FF. 05-12-07

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA110 and Dwg D2151

Identify as D2151

made by Rend

FF 06.04.10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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QC8
J



Comment: SECOND CHECK

J 06.04.19

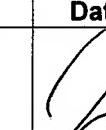
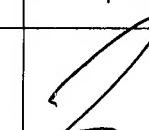
17

18

19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/04/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/04/19	3	6 prints scrav. - .098 holes off by $\frac{1}{2}$ the hole. CNC part made by hand.	 06/04/19	Scrap: destroy no replace	 06/04/19	 06/04/19	 06/04/19	 06/04/19

NOTE: Date & initial all entries

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Drawing Name: DOUBLER

Job Number: 25156

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

FF 06.04.19

19

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DC 06/04/22

19

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/04/22

19

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10/04/24

19

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST26

10/04/24

19

11.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/04/24

19

Job Completion



✓ 06.04.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25156
Description: Packer	Part Number:	D2151
Inspection Dwg: D2151 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

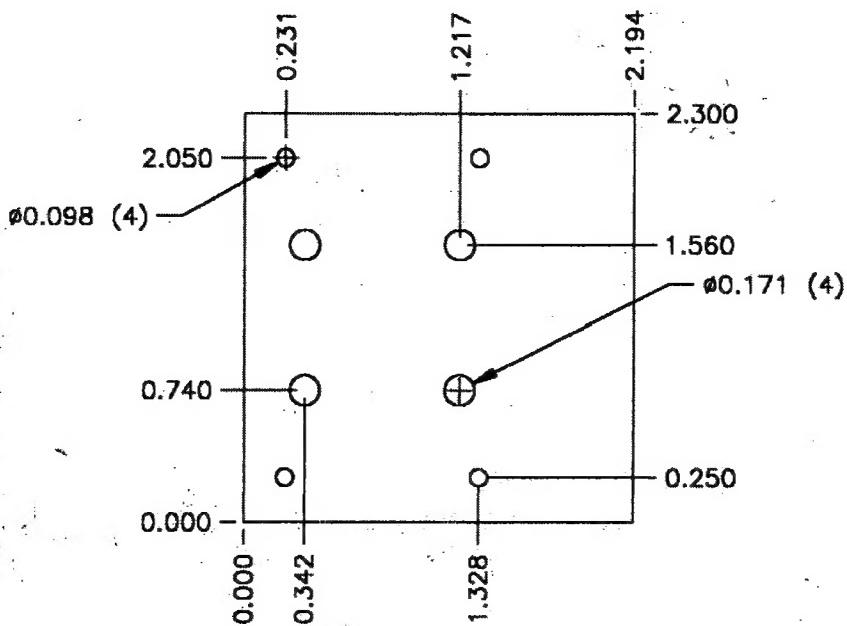
X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	

DART

DESIGN B WILLIAMS	DRAWN BY K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BL</i>	DRAWING NO. D2151	REV. A SHEET 1 OF 1
DATE 95:05:01		TITLE PACKER	SCALE 1:1

RELEASED
96/06/13 BU

MATERIAL: 2024-T3, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS

WORK ORD P
NO. 35156